Work Order II Monday, April 25, 201										*		Page 1
Item ID: D321 Revision ID: Item Name: Door Start Date: 4/25/2	Panel 2011 S	tart Qty: 8.00		Accept	Cust Item			 \$	_	~ 1	.==:::=: =:=:	
Required Date: 4/29// Reference: Approvals: Proc QC:	eess Plan:	Req'd Qty: 8.00	Date: <u>//-01-2-5</u>	Tooling: SPC (Y/N):		ate:		I		· .		
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty			Insp. Stamp
Draw Nbr D3213	Revisio	on Nbr				,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		-	-			,
Waterjet FLOW CNC Waterjet	FL	OW WATER JET Memo 1-Cut as pe Deburr if no	r Dwg D3213 □ Dwg Rev: ccessary	0.00 0.00 ♣ □Prog Rev:	A □2-			1BII-	<u>5-3</u>	Ŷ)	
110 QC Quality Control	Q	C2- Inspect parts off n Memo	nachine FAI/FAIB	0.00				HBII-	¢-3			

Quality Control

120 QC

Memo

QC8- Inspect parts - second check

0.00 M/C

(A)

						_			
		WC	RK ORDER CHAN	GES		-			
STEP	PRO	OCEDURE CHA	NGE	· .	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	7 :	Date: _	
R	esolution:	Disposition	n:	QA	N/C CIO	sed:		Date: _	
	1	WORK ORD	ER NON-CONFORM	MANCE	(NCR)			
OTED	Description of NC					Verific	ation	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Section	on C	Chief Eng	QC Inspector
					ż				
				٠٠					
		:PAR #: Resolution:	STEP PROCEDURE CHA PAR #: Fault Cate Resolution: Disposition WORK ORDI STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Initial Action Description	:PAR #: Fault Category: NCI Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes f Resolution: Disposition: QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PAR #: Fault Category:NCR: Yes_NoDQ/_ Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section C Section A Chief Eng C

Work	Orde	r ID	689	06
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Monday, April 25, 2011 10:52:32 AM

Page 2

Item ID:

D3213-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Required Date: 4/29/2011

Item Name:

Door Panel

4/25/2011

Start Oty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Tool ID

Reference:

Λ	nı	٦r	Λì	101	s:
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Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Tool # Plan

Code

Run

Accept

Qty

Start

Reject

Qty

Stop

Reject

Number



Insp.

Stamp

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation

Description

Small Fab

Chemical Conversion Coat per QS1005 4.1

Set Up/ **Run Hours**

0.00

0.00

140

HandFinish

Memo

0.00

0.00

Hand Finishing

150

Quality Control

QC3- Inspect Part Finish

Memo

0.00 =7 m/h 11/05/04

W/O:			V	ORK ORDER CHANGI	ES			and the second s	
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•							
Part No	4	PAR #:	Fault Cat	egory:	NCR: Ye	s No DO	QA:	Date: _	
	Re	esolution:	Dispositi	on:	QA: N/C	Closed: _		Date: _	
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (NO	CR)			
DATE	STEP	Description of NC		Corrective Action Section		Verif	ication	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	1&r _{Sec}	ction C	Chief Eng	QC Inspector
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Work Order ID 68906

Monday, April 25, 2011 10:52:32 AM



Page 3

Item ID:

D3213-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Start Date:

Door Panel

4/25/2011

Start Qty: 8.00

Operation

Description

Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Required Date: 4/29/2011

Date: _____

Identify as per dwg & Stock Location 333/5

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

160

Packaging

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

M/5/6 18

	•											
W/O:				V	VORK OR	DER CHA	NGES			***************************************		,
DATE	STEP		PROC	EDURE CI	HANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		,										AUTO-100-100-100-100-100-100-100-100-100-10
			÷									
Part No	:	PAF	R #:	_ Fault Ca	itegory:		NCI	R: Yes I	No DQ	A:	Date:	
	·R	esolution:		_ Disposi	tion:		QA:	N/C Clo	sed:		Date:	
NCR:	,		W	ORK OR	DER NON	-CONFOR	RMANCE	(NCR)			
DATE	OTED	Description of	NC		Corrective		Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A		Initial Action Description Chief Eng Chief Eng			on	Sign & Section			Chief Eng	QC Inspector
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Picklist Print

Monday, April 25, 2011 10:52:39 AM

Work Order ID: 68906

Parent Item: D3213-1

Parent Item Name: Door Panel



Start Date: 4/25/2011

Required Date: 4/29/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A 05-11-17 New Issue

JLM

IPP Rev:B 07-02-13 Now on Waterjet JLM

IPP Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	330.5700	0.4714	3.969684			
										151			

2024-T3 .063 sheet

Location	Loc Qty	Loc Code	·
MAT022	330.57		
113867	1.19		
117018	41.38		
117392	288		47392



W/O:	-		V	VORK ORDER C	HANGES					
DATE	STEP	PRO	CEDURE CI			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				•						
Part No	•	PAR #:	Fault Ca	itegory:	· · · · · · · · · · · · · · · · · · ·	ICR: Yes	No DQA:		_ Date: _	
	R	esolution:	Disposit	tion:	G	A: N/C Cld	osed:		Date: _	
NCR:				DER NON-CONI					-	
DATE	STEP	Description of NC		Corrective Action			Verifica	tion	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Desc Chief En	ription 9	Sign & Date	Section	ı C	Chief Eng	QC Inspector
				,						
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DART AEROSPACE LTD	Work Order:	68906
Description: Door Panel	Part Number:	D3213-1
Inspection Dwg: D3213 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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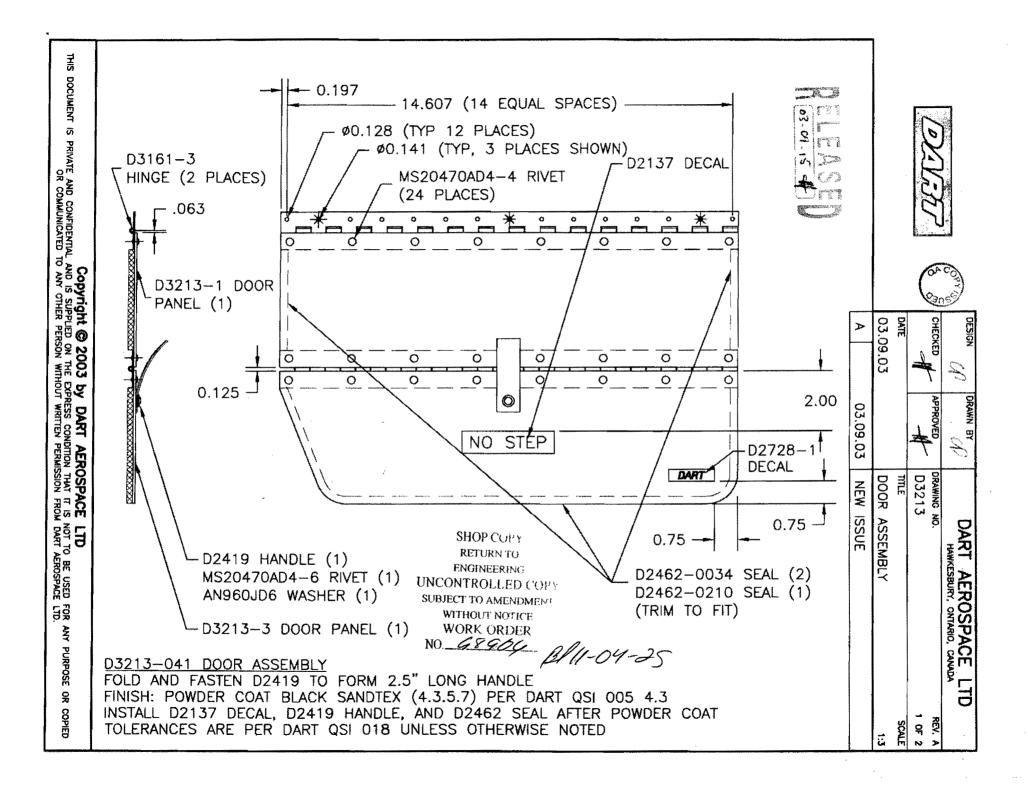
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.00	+/-0.030	15.00	8		T 1301	
4.47	+/-0.030	4.472	7		V 1802	
14.400	+/-0.005	14,400	7		1	
0.300	+/-0.010	301	У		V	
Ø0.128	+0.005/-0.001	131	>		V	
Pitch 2.057	+/-0.005	P20.6	8		ν	
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: الديء	Date: 11/4 \	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	03.12.15	New Issue	P/O D350-567-015/-025/-031	KJ/RF	
В	08.11.27	Diameter symb	ol added to dimension 0.128	KJ/EC	N.
L	-			7.71	

W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									5
Part No	*	PAR #:	Fault Cate	egory:	NCR: Yes	No DC	A:	Date: _	
	Re	esolution:	Disposition	on:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	OTED	Description of NC			tion B	Verifi	cation	Approval Chief Eng	Approval QC Inspector
DATE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C		

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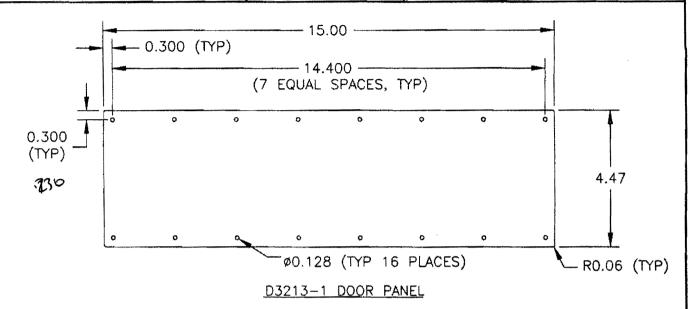
W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	By Date Qty Approx Chief En- Prod Mg						
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Part No		PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA: _	Date: _					
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DATE	OTED	Description of NC	Corrective Action Section B			Verificatio	n Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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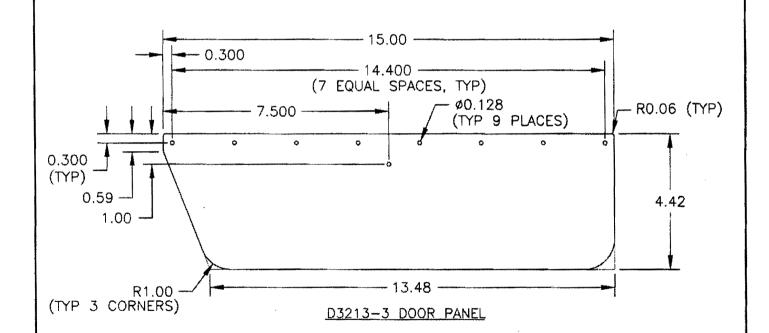
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	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
1	CHECKED MI	APPROVED.	DRAWING NO.	REV. A
1	d	all	D3213	2 OF 2
	DATE		TITLE	SCALE
	03.09.03		DOOR ASSEMBLY	1:3





D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:	-		V	ORK ORDER CHANGE	S					<u> </u>		
DATE	STEP	PROC	EDURE CH		GE By Date Qty Chie				Approval Chief Eng / Prod Mgr	Eng/		
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		<i>4</i>				-		ŧ				
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Part No	•	PAR #:		egory:	NCR: Y	es N	o DQ	A:	Date:	,		
			Disposition: Q/									
NCR:	Marie a	We	ORK ORI	DER NON-CONFORMAL	VCE (N	CR)			•			
DATE		Description of NC	Corrective Action Section B			Sign & Section C		cation	Approval Chief Eng	Approval QC Inspector		
DATE	STEP Description of NC Section A		Initial Action Description Chief Eng Chief Eng									
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